

## AMENDMENTS TO THE ABSTRACT:

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Please amend page 14 as follows:

### ABSTRACT

~~The invention concerns a~~ A method for determining a deviation of at least one regulating variable on chip removal machines with a mechanical drive for a tool and/or a workpiece, regulated by a control system, wherein the regulation comprises a plurality of values  $[[C, X, Z]]$  of at least three spatial axes  $[[c, x, z]]$  for the control system and for the drive, and the values  $[[C, X, Z]]$  have a functional relation ~~such as~~  $Z = f_{bi}(C, X)$  with the axes  $[[c, x, z]]$ . A protocol is prepared from a plurality of control system actual values  $[[C_{p,s}, X_{p,s}, Z_{p,s}]]$  detected by measuring means and/or selected drive actual values  $[[C_{p,a}, X_{p,a}, Z_{p,a}]]$  and a control system nominal value  $[[$ according to  $Z_{bi,s} = f_{bi}(C_{p,s}, X_{p,s})$  and/or a drive nominal value ~~according to~~  $Z_{bi,a} = f_{bi}(C_{p,a}, X_{p,a})$  is calculated at least in relation to an axis ~~the z-axis~~, and a control system differential value ~~according to~~  $D_{z,s} = Z_{p,s} - Z_{bi,s}$  and/or a drive differential value ~~according to~~  $D_{z,a} = Z_{p,a} - Z_{bi,a}$  is calculated at least in relation to the axis  $[[z\text{-axis}]]$ . ~~The invention also pertains to a~~ A chip removal machine which implements such a method is also disclosed.